

Date: Monday, 3/26/2007 2:48:31 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR DOUBLER
Job Number : 31508	
Estimate Number : 12680	
P.O. Number : <i>N/A</i>	Part Number : D35941
This Issue : 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3594 UNDER REVIEW
Prsht Rev. : NC	Project Number : AC0001
First Issue : 3/26/2007 Type : SMALL / MED FAB	Drawing Revision : <i>U/R</i>
Previous Run : 30495	Material : <i>N/A</i>
Written By : <i>[Signature]</i> 07-03-26	Due Date : 4/2/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S080

6061-T6 .080 Sheet



CERTIFICATE OF CONFORMITY
REQUIRED



Comment: Qty.: 0.0578 sf(s)/Unit Total : 0.0578 sf(s)

6061-T6 .080 Sheet

Batch: *M101178 ml 07 03 27* ①

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: *U/R*Prog Rev: *U/R* *ml 07 03 27* ①

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

*ml 07 03 27*

①

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



ENGINEERING
APPROVAL

07.07.27

Comment: SECOND CHECK

07.03.27 ①

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

07 04 30 ①

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 31508

Part Number: D35941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

ENGINEERING
APPROVAL
07-04-30



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/A w/U 00071

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-04-30

Job Completion

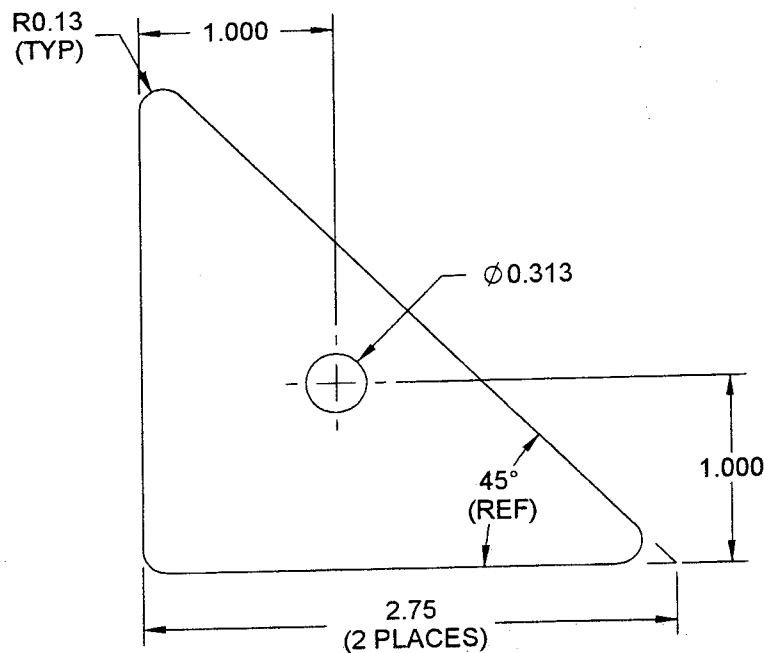


U 07-04-30

S.1 Alodine JAW QSI ~~005~~ 4.1 ~~070430~~ 070430 ①

PRELIMINARY ISSUE

DESIGN <i>13</i>	DRAWN BY <i>13</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED	DRAWING NO. D3594	REV. A SHEET 1 OF 2
DATE 07.01.29		TITLE DOOR DOUBLER	SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	



D3594-1 DOOR DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

EIT Done

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DART AEROSPACE LTD		Work Order: 31508
Description: Door Doubler		Part Number: D3594-1
Inspection Dwg: D3594 Rev: U/R		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☒ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A ϕ 0.313	+0.005-0.001	0.314	✓		VERN	
B 1.000	+/- 0.010	1.002	✓		VERN	
C 1.000	+/- 0.010	1.003	✓		VERN	
D 0.080	+/- 0.010	0.078	✓		VERN	
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: ml. mm	Audited by:	Prototype Approval:
Date: 07.03.27	Date: 07.03.27	Date: N/A 07.03.27

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	